

Work Order ID 91542

91542

Page 1

October-12-12 11:26:57 AM

Item ID: D206-628-014

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step RH

Start Date: 10/11/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/19/12 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12-10-12 Tooling:

Date: _____

Run Start ***NR1***

QC:

Date: _____ SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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DSI9500	A
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IIN-D206-628	Rev F
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100	DOCUMENT CONTROL	0.00
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100

DC	Memo <u>M.D.</u>	0.00
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Document Control Photocopy blue file and type labels as per PPP D206-628-014 CHG-006

DAS
06
9-88

13/8/6

(4)

110	Pick Kit	0.00
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110

Packaging	Memo	0.00
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Packaging

4x

M.D. 13-08-1

8

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: *Alt*

Date: 13/08/22

QA Closed: *Alt*

Date: 13/08/14

Work Order: <u>91542</u> Part No. <u>D206-620-014</u> NCR No. <u>13-2939</u>				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input checked="" type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input checked="" type="checkbox"/>				Parts missing from w/o to L&W parts list Re w/o to BOM not work	DAS 16 08-20 Q57042 13/07/14	ADD missing part NAS-1149C043212 x 8 Pz Kit B 122441 8x (4 Kit)	<i>Alt</i> 13/08/14	<i>Alt</i> 13/08/14	DAS 16 08-20 Q57042 13/07/14		
Equip/Tooling <input type="checkbox"/>						update w/o to BOM ADD copy of BOM file	<i>Alt</i> 13/08/14				
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY *Def.*

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
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<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	<input type="checkbox"/> Other
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Work Order ID 91542

91542

Page 2

October-12-12 11:26:57 AM

Item ID: D206-628-014

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step RH

Stop

NS2

Start Date: 10/11/12 Start Qty: 4.00

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Cust Item ID:

Required Date: 10/19/12 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-628-014								
	Location: <u>6.671</u>								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS 06/13/13

13/8/13 (4)

(4) 13/8/13 S-J

MLJ 13-08-14
p/13-8-13

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

Picklist Print

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Page 1

Work Order ID: 91542

Parent Item: D206-628-014

Parent Item Name: Heli-Access-Step RH

Start Date: 10/11/12

Required Date: 10/19/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM
 IPP Rev:E as per ecn 1118 08-02-05 DD verified by:
 IPP rev F ncr 09-004 09.01.09 EC verified by:DD IPP Rev:G per DS19500 DD
 10.03.01 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C4A BOLT		Purchased	No			110	Each	1,396.0000	2	8		11-13-08-1	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST350		1396			126105				
				120187		31							
				120521		28							
				120769		38							
				121205		61							
				121556		8							
				122151		2							
				122416		4							
				122814		931							
				123021		293							
AN4G13A BOLT		Purchased	No			110	Each	118.0000	4	16		11-12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST356		100			124805				
				122808		100							
				ST357		18							
				121827		3							
				122141		15							
AN4C14A Bolt		Purchased	No			110	Each	166.0000	4	16		11-11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		20			126176(3x)				
				118706		20							
				ST357		146							
				118706		46							
				123021		100			18x				

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>																								
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>																								
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>																								
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FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

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Page 2

Work Order ID: 91542

Parent Item: D206-628-014

Parent Item Name: Heli-Access-Step RH

Start Date: 10/11/12

Required Date: 10/19/12

Start Qty: 4.00

Required Qty: 4.00

AN4C15A

Bolt

Purchased

No

110

Each

189.0000

Location

Loc Qty

Loc Code

FG

2

120360

2

ST358

187

115835

2

118706

3

120360

182

125388

M.D. 13-08-1

AN960C416

washer

D2731-7

Mounting Lug

NAS1149C0463R

Purchased

No

110

Each

0.0000

Manufactured

No

110

Each

122.0000

Location

Loc Qty

Loc Code

ST

-50

ST466

40

89726

40

ST467

50

85477

50

ST468A

4

71860

4

ST469

78

78922

28

B97497

M.D.

M.D.

D2732

Rubber Extrusion

Manufactured

No

110

f

277.1795

Location

Loc Qty

Loc Code

ST410

277.1794684

70987

0.3

83560

276.879468

110

Each

0.0000

B94725

8x3" x (4)
Kit

M.D.

9.1640

D2841-042

Step Assembly RH, 206 Float

Manufactured

No

October-12-12 11:26:56 AM

Shop Packet Print

Page 2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

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Page 3

Work Order ID: 91542

Parent Item: D206-628-014

Parent Item Name: Heli-Access-Step RH

Start Date: 10/11/12

Required Date: 10/19/12

Start Qty: 4.00

Required Qty: 4.00

D2845

Arm

Manufactured No

110 Each 21.0000

2 (8) M.H. 13-08-1

Location

Loc Qty

Loc Code

ST265

21

52269

2

56828

19

Manufactured No

110 Each 112.0000

8x (16) M.H.

Location

Loc Qty

Loc Code

ST465

40

89729

40

ST479

72

80217

52

82760

20

Manufactured No

110 Each 15.0000

398328 (10x)
B78921 (6x)
4 (4) M.H.

Location

Loc Qty

Loc Code

ST465

15

58980

1

58985

1

62977

13

Purchased No

110 Each 1,529.0000

4x (48) M.H.

Location

Loc Qty

Loc Code

FG

36

104603

36

ST301

349

119546

2

121162

25

121652

322

ST315

500

123021

500

ST318

644

122141

644

125654

D4064-041

Mounting Lug

MS21043-4

Nut

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NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Page 4

Work Order ID: 91542

Parent Item: D206-628-014

Parent Item Name: Heli-Access-Step RH

Start Date: 10/11/12

Required Date: 10/19/12

Start Qty: 4.00

Required Qty: 4.00

NAS1149C0363R

Washer

Purchased No

110

Each

4,524.0000

2

8

11.10.13-08-1

Location

Loc Qty

Loc Code

297

2000

122441

2000

ST297

2524

114742

2324

122063

200

8x

NAS151SH3

Washer

Purchased No

110

Each

36.0000

2

8

11.10.13-08-1

Location

Loc Qty

Loc Code

ST277

36

119438

2

120518

26

121415

8

125654

NAS151SH4L

WASHER

Purchased No

110

Each

353.0000

24

96

11.10.13-08-1

Location

Loc Qty

Loc Code

FG

8

103691

8

ST277

345

118709

2

120390

343

125654

NAS1149C0432R

50

8x 122441

32

11.10.13-08-6

CR

October-12-12 11:26:57 AM

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NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-628 REV. F

REF FAA STC: SA00500SE

REF TCCA STC: SH98-14

REF EASA STC EASA.IM.R.S.01339

PURPOSE:

UNMODIFIED D206-628-013/-014 STEP INSTALLATIONS AT CHANGE 005 (OR EARLIER) WILL NOT INSTALL AT THE 18.50" HEIGHT REQUIRED FOR COMPATIBILITY WITH APICAL TRI-BAG FLOATS.

CHANGE:

D206-628-013/-014 STEP INSTALLATIONS AT CHANGE 006 (OR LATER) CONTAIN NEW MOUNTING LUGS FOR COMPATIBILITY WITH APICAL FLOATS.

CONTRARY TO INSTALLATION INSTRUCTIONS IIN-D206-628, FOR COMPATIBILITY WITH APICAL TRI-BAG FLOATS, THE D206-628-013/-014 STEP INSTALLATIONS SHOULD BE INSTALLED AT A HEIGHT OF 17.25" PER FIGURE 1 OF THIS SERVICE INSTRUCTION.

WHEN INSTALLING THE MOUNTING LUGS, IT IS ACCEPTABLE TO USE LONGER/SHORTER AN4C BOLTS AS REQUIRED AND/OR INSTALL EXTRA AN960C416/416L WASHERS UNDER THE BOLT HEADS TO ENSURE 1.5 TO 4 THREADS IN SAFETY.

PARTS LIST OF SECTION 5.2 (PG. 12) OF IIN-D206-628-013/-014 REV. F IS AMENDED AS FOLLOWS:

QTY -013	QTY -014	QTY -023	QTY -024	QTY -033	QTY -034	Part Number	Description
X						D206-628-013	206 A/B FLOAT STEP INSTALLATION, LH
	X					D206-628-014	206 A/B FLOAT STEP INSTALLATION, RH

WAS:

2	2					D2731-3	MOUNTING LUG
2	2					D2731-7	MOUNTING LUG
2	2					D3394-041	MOUNTING LUG
2	2					D3394-043	MOUNTING LUG
16	16					AN960C416L	WASHER

IS:

4	4					D2731-7	MOUNTING LUG ✓
4	4					D3394-043	MOUNTING LUG ✓
1	1					D4064-041	MOUNTING LUG (NEW) ✓
1	1					*D4064-1	LUG
2	2					*MS35489-93	GROMMET
16	16					AN960C416	WASHER ✓

* DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

SHOWN
REF 98-10
ENGINE OPA
UNCONTROLLED
SUBJECT TO AEC
WITHDRAWN
NO. 01542 HCS
12-10-12

A	NEW ISSUE	CP	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	GP	DART AEROSPACE USA, INC	
DRAWN	GP	PORT HADLOCK, WA	
CHECKED	3	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9500	SHEET 1 OF 4
APPROVED	H	TITLE	SCALE
DE APPR.	H	MOUNTING LUG CHANGE	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC	
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THE DSI-9500-011 LUG UPGRADE KIT IS AVAILABLE TO UPDATE EXISTING D206-628-013/-014 STEPS TO CHANGE 006. THE UPGRADE KIT INCLUDES ADDITIONAL LUGS FOR STEPS INSTALLED WITH APICAL TRI-BAG FLOATS (AT 17.25" HEIGHT). EXISTING D206-628-013/-014 STEPS INSTALLED WITH OEM FLOATS (AT 15.00" HEIGHT) DO NOT REQUIRE THE KIT. THE UPGRADE KIT SHOULD BE INSTALLED PER THIS SERVICE INSTRUCTION AND IIN-D206-628 REV. F.

QTY -011	Part Number	Description
X	DSI-9500-011	LUG UPGRADE KIT, 206 A/B FLOAT STEP
2	D2731-7	MOUNTING LUG (REPLACES D2731-3 MOUNTING LUG)
8	D2732-030	RUBBER CUSHION
2	D3394-043	MOUNTING LUG (REPLACES D3394-041 MOUNTING LUG)
1	D4064-041	MOUNTING LUG (REPLACES ONE D3394-043 FOR APICAL TRI-BAG FLOAT COMPATIBLE INSTALL)
4	AN4C13A	BOLT
4	AN4C14A	BOLT
4	AN4C15A	BOLT
16	AN960C418	WASHER
8	AN960C416L	WASHER
24	NAS1515H4L	WASHER
12	MS21043-4	NUT

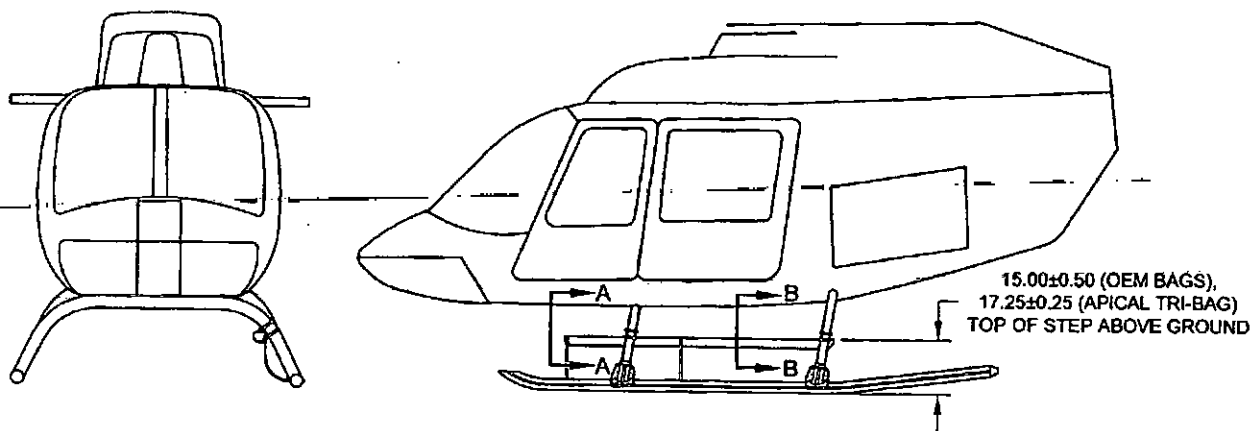
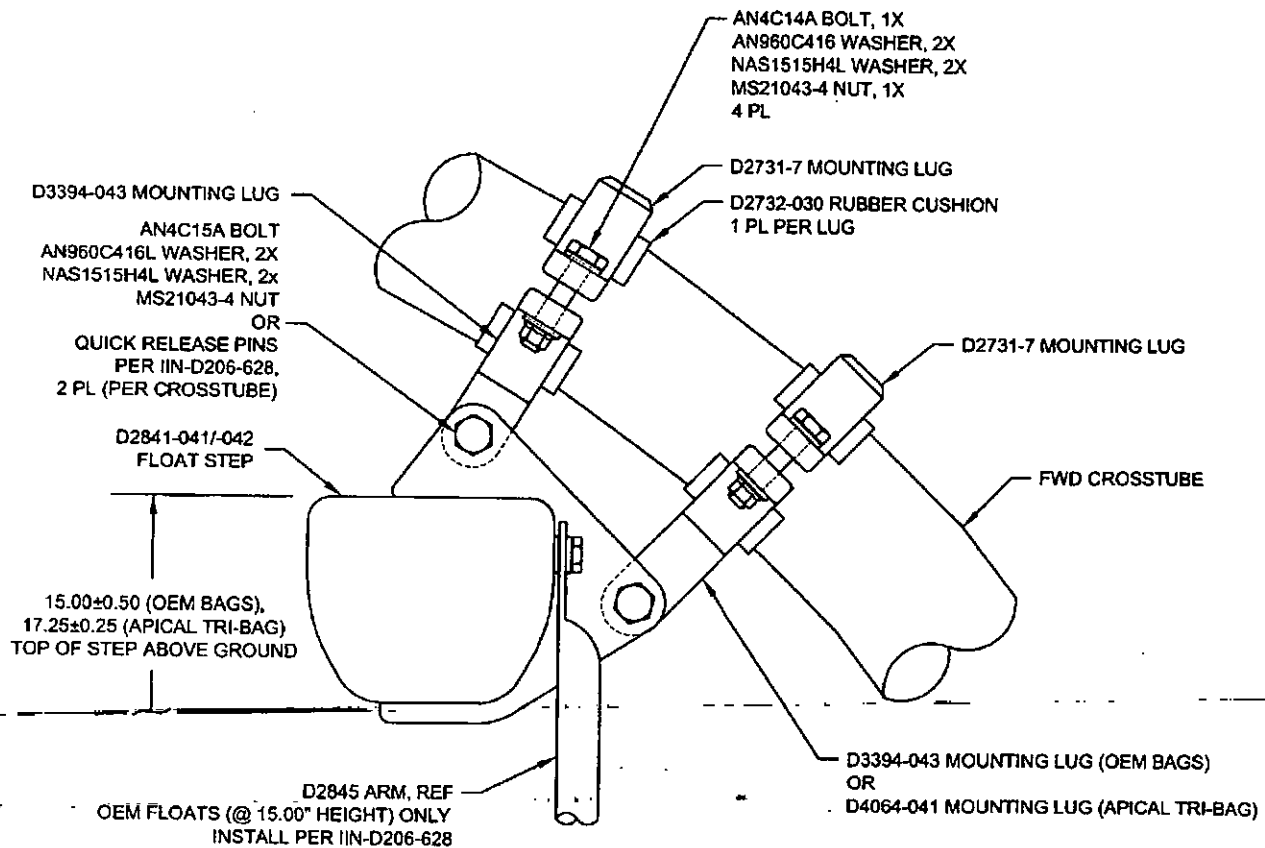


FIGURE 1
D206-628-013 (SHOWN) / -014 (OPPOSITE)
206 A/B FLOAT STEP INSTALLATION

DESIGN	99	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	99		
CHECKED	99	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9500	SHEET 2 OF 4
APPROVED	99	TITLE	SCALE
DE APPR.	99	MOUNTING LUG CHANGE	NTS
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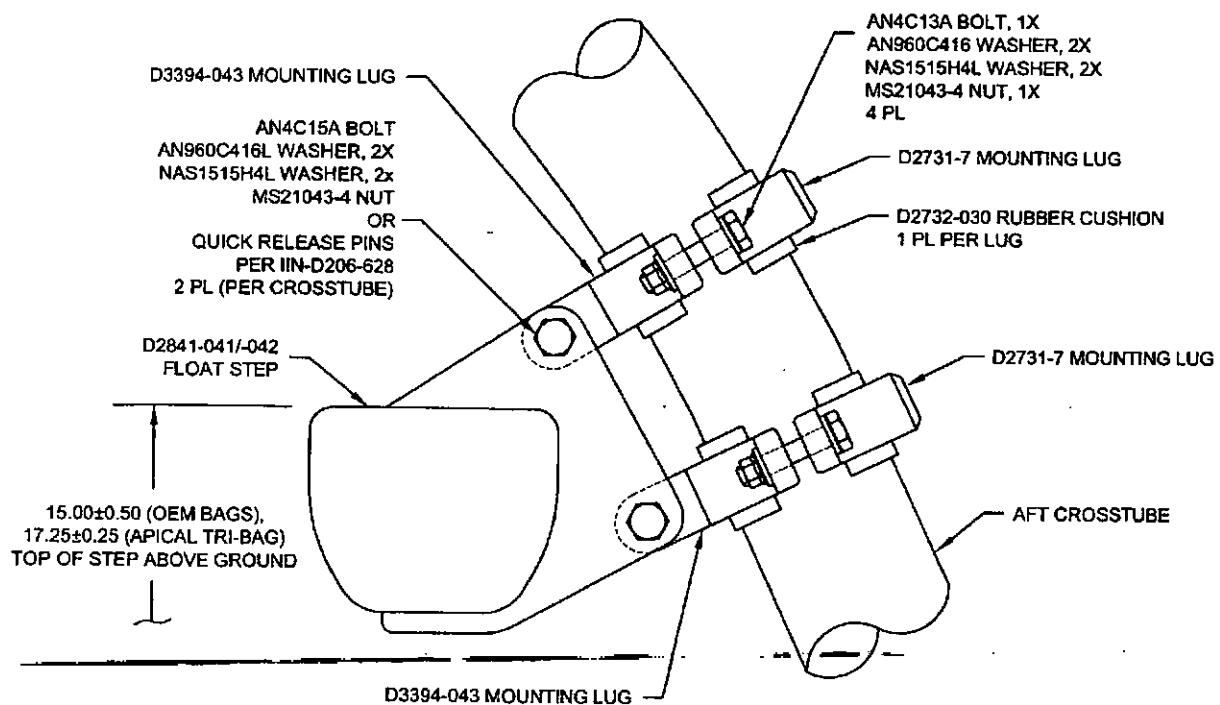
91542



SECTION A-A
FWD CROSSTUBE CLAMPING DETAIL

DESIGN	<i>JP</i>	DART AEROSPACE USA, INC	
DRAWN	<i>JP</i>	PORT HADLOCK, WA	
CHECKED	<i>B</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>N/A</i>	DSI 9500	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MOUNTING LUG CHANGE	NTS
DATE	10.01.29	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

91542



SECTION B-B
AFT CROSSTUBE CLAMPING DETAIL

DESIGN	99	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	99		
CHECKED	99	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9500	SHEET 4 OF 4
APPROVED	99	TITLE	SCALE
DE APPR.	99	MOUNTING LUG CHANGE	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

91542

Work Order ID 91542

October-12-12 11:26:57 AM

91542

Page 1

Item ID: D206-628-014

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Heli-Access-Step RH

Start Date: 10/11/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/19/12 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan: MLJ

Date: 12-10-12 Tooling:

Date:

Stop

NR2

QC:

Date: SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr Revision Nbr

DS19500
IIN-D206-628

A
Rev F

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-014 CHG 006

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

MLJ 13-08-01

4x

11.10.13-08-1

